



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3316-20
Job Sheet 170954



Part No: RBE350A93-3316-20

Job Qty: 6 ea

Part Name: Rotating Star Replacement Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3316-20 REV:C IPP REV A 18.01.23 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Small Fab-2		MCL
110	Small Fab	6 pcs		1/31/18	0.00	6.00	Small Fab-3		MCL
120	QC	6 pcs		1/31/18	0.00	0.00	QC5		SP
130	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3-1		SP
140	QC21-SA	6 Ea		1/31/18	0.00	0.00	QC21		

Part Op 110 - Pick kit as per DWG.
Descriptions:

DAS
21
9-86

MAR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1040-E	Case	6 pcs (1 ea)	90-Start up Operation	
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	6 Ea (1 ea)	90-Start up Operation	
RBE350A93-3316-20-5	Top Foam	6 (1 ea)	90-Start up Operation	
RBE350A93-3316-20-7	Bottom Foam	6 (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NA • APP-1040-E	6	0	0
	RBE350A93-3316-20-1 5046619	6	0	0
	NA • RBE350A93-3316-20-5	6	0	0
	NA • RBE350A93-3316-20-7	6	0	0

DAS
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9-86

Part Specifications

Specifications could not be found.

Plex 1/24/18 2:50 PM Dart.lajeunesse.marie

MCL 327

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



CA Clerk: _____ Date: _____



Container No: S054960



Part: RBE350A93 - 3316 - 20

Job No: 170954

Serial No/Batch: S054960

Revision: C

Inspector: _____

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/26/18

Work Order update only ☐

ACTION		AGAINST DEPARTMENT/PROCESS				
Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Approved ☐	Large Fab ☐	Composite ☐	Supplier ☐			
		QTY Effective :			MRB (QSI042) Approval	
		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	

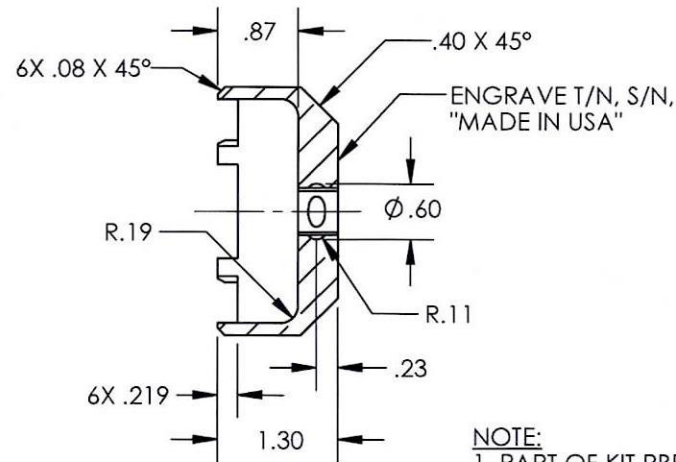
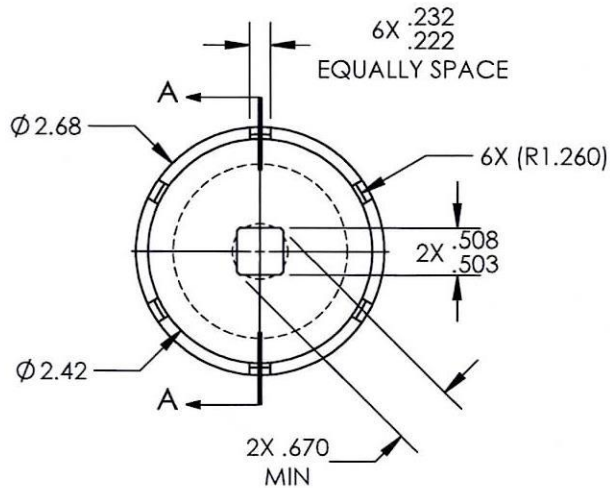
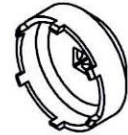
FAULT CATEGORY		
☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Countersink	☐ Off-set	☐ Drawing
☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

Needs W/O

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		OPENED TOLERANCES ON I.D., O.D., LENGTH, AND TOOTH WIDTH, WAS .232 ±.005. ALSO ADDED BALL LOCK GROOVE TO 1/2 in. DRIVE.	9/28/2009	WP	DW
1A		ADDED MISSING Ø.600 DIMENSION.	9/15/2011	RJC	RW
2		CH'D RADIUS WAS .094 IS .109.	4/19/2013	CFS	GE
2A		CH'D T/N WAS RBEA93-3316-20 IS RBE350A93-3316-20. CH'D TOOL NAME WAS WRENCH, TAIL ROTOR SPIDER NUT IS ROTATING STAR REPLACEMENT WRENCH.	10/23/2013	CFS	
3	17-0130	UPDATED TO NEW DRAFTING STANDARD. CH'D DIM WAS .505 SQUARE IS 2X .508/.503. ADDED DIM 2X .670. CH'D MAT'L WAS 4140 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-32. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. ADDED NOTE 2 SHT 1.	6/1/2017	RJC	JAG



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120957 MGS
1001-28

NOTE:

- PART OF KIT RBEA62309.
- REFERENCE EUROCOPTER T/N 350A93-3316-20.

DART AEROSPACE	
TITLE ROTATING STAR REPLACEMENT WRENCH	
DWG NO. RBE350A93-3316-20	REV 3
MAT'L 4140/4142 HEAT TREAT RC 28-32 FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: RJC 06/01/2017 CHECKED: DD 06/02/2017 OPPS APPR: AA 06/05/2017 QA APPR: JL 06/13/2017 APPROVED: JAG 06/15/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL AS350/355	
SCALE 1:2	DATE 6/1/2017
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	WRENCH	4140/4142		